What is claimed is:

1. A hand-held writing instrument comprising

a tubular barrel housing a writing mechanism and a writing tip,

said barrel having externally affixed thereto a three-dimensional metal casting extending circumferentially around said barrel.

2. The instrument of claim 1 being a pen.

3. The instrument of claim 1 being a pencil.

4. The writing instrument of claim 1 having a retractable writing mechanism and writing tip.

5. The writing instrument of claim 1 having a fixed writing mechanism and writing tip.

6. The writing instrument of claim 1 wherein said barrel is made of wood.

7. The writing instrument of claim 1 wherein said barrel is made of plastic.

8. The writing instrument of claim 7 wherein said plastic is selected from the class comprising polycarbonates, nylon, DELRIN®, ABS and polyethylene.

9. The writing instrument of claim 1 wherein said metal is pewter.

10. The writing instrument of claim 1 wherein said metal is an alloy of aluminum, zinc, tin, or combination thereof, which has a sufficiently low melting temperature to permit centrifugal casting thereof.

11. The writing instrument of claim 1 wherein said metal casting has a plated coating thereover of a precious metal.

12. The writing instrument of claim 11 wherein said precious metal is gold.

13. The writing instrument of claim 11 wherein said precious metal is silver.

14. The writing instrument of claim 1 being a pen having a retractable writing mechanism and tip wherein said barrel is made of wood and said metal casting is pewter.

15. The writing instrument of claim 1 being a pencil having a retractable writing mechanism and tip wherein said barrel is made of wood and said metal casting is pewter.

16. The writing instrument of claim 1 being a pen having a retractable writing mechanism and tip wherein said barrel is made of plastic and said metal casting is pewter.

17. The writing instrument of claim 1 being a pencil having a retractable writing mechanism and tip wherein said barrel is made of plastic and said metal casting is pewter.

18. A centrifugal casting process for casting molten pewter or other metal alloy having a sufficiently low melting temperature to permit centrifugal casting thereof onto a workpiece, said process comprising:

preparing an elongate, tubular workpiece onto which a three-dimensional metal casting is to be affixed, wherein said workpiece has a decomposition temperature below that of said molten alloy,

coating said workpiece with a heat-resistant coating material,

placing said coated workpiece into a prepared centrifugal casting mold,

casting said molten metal alloy onto and around said coated workpiece by centrifugal casting thereon,

cooling and opening the casting mold, thereby

producing a three-dimensional metal casting on and around said workpiece.

19. The process of claim 18 wherein said workpiece is a wooden pen barrel and said coating is a heat resistant varnish.

20. The process of claim 19 wherein said varnish comprises about 1-2.5% ethylbenzene, 2.5-10% xylol, 50-90% ethylacetate and 2.5-10% 2-methoxy-1-methyl-1-ethyl acetate, wherein percentages are by weight of the total compositions.

21. The process of claim 18 wherein said workpiece is a wooden pencil barrel and said coating is a heat resistant varnish.

22. The process of claim 21 wherein said varnish comprises about 1-2.5% ethylbenzene, 2.5-10% xylol, 50-90% ethylacetate and 2.5-10% 2-methoxy-1-methyl-1-ethyl acetate, wherein percentages are by weight of the total compositions.

23. The process of claim 19 wherein said coating is a varnish commercially available and identified hereinabove as product designation No. 660-Q0237-00.

24. The process of claim 21 wherein said coating is a varnish commercially available and identified hereinabove as product designation No. 660-Q0237-00.

25. The process of claim 19 wherein said wooden pen barrel has been pretreated prior to coating and casting with a moisture stabilizing agent.

26. The process of claim 21 wherein said wooden pencil barrel has been pretreated prior to coating and casting with a moisture stabilizing agent.

27. The process of claim 18 wherein said workpiece is a plastic pen barrel and said coating is a heat resistant varnish.

28. The process of claim 18 wherein said workpiece is a plastic pencil barrel and said coating is a heat resistant varnish.

29. The process of claim 27 wherein said coating is a varnish commercially available and identified hereinabove as product designation No. 665-Q0429-01.

30. The process of claim 28 wherein said coating is a varnish commercially available and identified hereinabove as product designation No. 665-Q0429-01.

31. The process of claim 18 wherein said metal alloy is an alloy of aluminum, zinc, tin, or combination thereof, which has a sufficiently low melting temperature to permit centrifugal casting thereof.

32. The process of claim 18 wherein said metal alloy is pewter.

33. The process of claim 18 wherein said metal casting is filigreed.

34. The process of claim 18 including coating said casting with a precious metal.

35. The process of claim 32 wherein said precious metal is gold.

36. The process of claim 32 wherein said precious metal is silver.

37. The process of claim 18 for producing a writing instrument having a wooden barrel having externally affixed thereto a three-dimensional pewter casting extending circumferentially around said barrel.

38. The process of claim 18 for producing a writing instrument having a plastic barrel having externally affixed thereto a three-dimensional pewter casting extending circumferentially around said barrel.